



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4148-1
Job Sheet 169909



(D)

Part No: D4148-1

Job Qty: 40 ea

Part Name: Crosstube Lug Plate, Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/11/18

Type: Stock

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.10.29 as per revC DD verf:EC
IPP REV:C 11.03.02 AS PER DWG REV.D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	1/10/18	1/10/18	0.00	0.00	Start Up Waterjet		SC 18/01/17
100	Waterjet	40 pcs	1/11/18	1/11/18	0.06	8.62	Waterjet1		SC 18/01/17
110	QC	40 pcs	1/11/18	1/11/18	0.00	0.00	QC2 Waterjet-3		SC 18/01/17
120	QC	40 pcs	1/11/18	1/11/18	0.00	0.00	QC8-4		38
150	Packaging	40 pcs	1/11/18	1/11/18	0.00	0.00	Packaging3	57080	AT 18/01/17
160	QC21-SA	40 Ea	1/11/18	1/11/18	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	14	81	0	0

5032211
11.54

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Lug Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0,130	
2	Fwd Crosstube Lug Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	0,192	
3	Fwd Crosstube Lug Plate	0.380Inches + 0.006 - 0.001	0.386 0.379	0,380	
4	Fwd Crosstube Lug Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0,257	
5	Fwd Crosstube Lug Plate	0.500Inches + 0.008 - 0.001	0.508 0.499	0,501	
6	Fwd Crosstube Lug Plate	0.940Inches ± 0.030	0.970 0.910	0,945	
7	Fwd Crosstube Lug Plate	4.470Inches ± 0.030	4.500 4.440	4,468	
8	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	0,751	
9	Fwd Crosstube Lug Plate	8.470Inches ± 0.030	8.500 8.440	8,469	
10	Fwd Crosstube Lug Plate	8.096Inches ± 0.010	8.106 8.086	8,098	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																															
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																													
Description Work Order Deviation			Disposition																																														
Start up Operation 01/18/18 Job No: 169909 PART NO: D4148-1 Original Serial #: S033578 Revision: Operation: Change No: Crosstube Lug Plate, Fwd S033578 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																	
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Environment ☐</td> <td style="width:33%;">No Re-verification ☐</td> <td style="width:33%;">Pres. ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Benc ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Cent ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Crack ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crim ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crush ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER : ☐</td> </tr> </table>			Environment ☐	No Re-verification ☐	Pres. ☐	Design ☐	Operator ☐	Benc ☐	Doc/Data ☐	Offset/Setup ☐	Cent ☐	Equip/Tooling ☐	Supplier ☐	Crack ☐	Handling/Pre ☐	Training ☐	Crim ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crush ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER : ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">☐ Off-set</td> <td style="width:33%;">☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>			☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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11	Fwd Crosstube Lug Plate	5.430Inches ± 0.030	5.460 5.400	5,436
12	Fwd Crosstube Lug Plate	5.197Inches ± 0.010	5.207 5.187	5,199
13	Fwd Crosstube Lug Plate	4.733Inches ± 0.010	4.743 4.723	4,736
14	Fwd Crosstube Lug Plate	0.310Inches ± 0.010	0.320 0.300	0,312
15	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	0,753
16	Fwd Crosstube Lug Plate	0.375Inches ± 0.010	0.385 0.365	0,376
17	Fwd Crosstube Lug Plate	1.840Inches ± 0.030	1.870 1.810	1,843
18	Fwd Crosstube Lug Plate	0.920Inches ± 0.030	0.950 0.890	0,921
19	Fwd Crosstube Lug Plate	3.000Inches ± 0.010	3.010 2.990	3,000
20	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	0,751
21	Fwd Crosstube Lug Plate	0.625Inches ± 0.010	0.635 0.615	0,626
22	Fwd Crosstube Lug Plate	1.982Inches ± 0.010	1.992 1.972	1,984
23	Fwd Crosstube Lug Plate	0.991Inches ± 0.010	1.001 0.981	0,994
24	Fwd Crosstube Lug Plate	0.770Inches ± 0.030	0.800 0.740	0,772
25	Fwd Crosstube Lug Plate	1.540Inches ± 0.030	1.570 1.510	1,544
26	Fwd Crosstube Lug Plate	2.470Inches ± 0.030	2.500 2.440	2,470
27	Fwd Crosstube Lug Plate	0.820Inches ± 0.030	0.850 0.790	0,822
28	Fwd Crosstube Lug Plate	3.570Inches ± 0.030	3.600 3.540	3,572
29	Fwd Crosstube Lug Plate	1.230Inches ± 0.030	1.260 1.200	1,233
30	Fwd Crosstube Lug Plate	0.730Inches ± 0.030	0.760 0.700	0,731
31	Fwd Crosstube Lug Plate	0.125Inches ± 0.010	0.135 0.115	0,116
32	Fwd Crosstube Lug Plate	0.252Inches ± 0.000	0.255 0.252	0,254

Plex 1/3/18 10:50 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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